

Date: Friday, 17/10/2008 12:44:33 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ACCESS PANEL ASSY		
Job Number	: 42729		Part Number	: D3307041		
Estimate Number	: 13541		Drawing Number	: D3307 REV. A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 17/10/2008		Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 05/11/2008		
Previous Run	: 41034		Qty:	6 Um: Each		
Written By	:					
Checked & Approved By	: <u>JD 08-10-17</u>					
Comment	: Est: A 08.08.05 New issue EC verified by: DD					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S22GA	304/316 .032 Sheet	
		Comment: Qty.: 0.2600 sf(s)/Unit Total : 1.5600 sf(s) 304/316 .032 Sheet batch: <u>109057</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut D3307-1 as per Dwg D3307 Dwg Rev: <u>A</u> Prog Rev: <u>1B 8-10-22</u>	
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE bend as per dwg D3307	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:44:33 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASS'Y

Job Number: 42729

Part Number: D3307041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 D33073 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Gasket

B41057 (1X)

B42762 (6X)

8/10/08/27

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond gasket as per dwg D3307

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/10/08/27 (X2)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 111

8/10/08/27

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/10/08/29

Job Completion



8/10/08/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

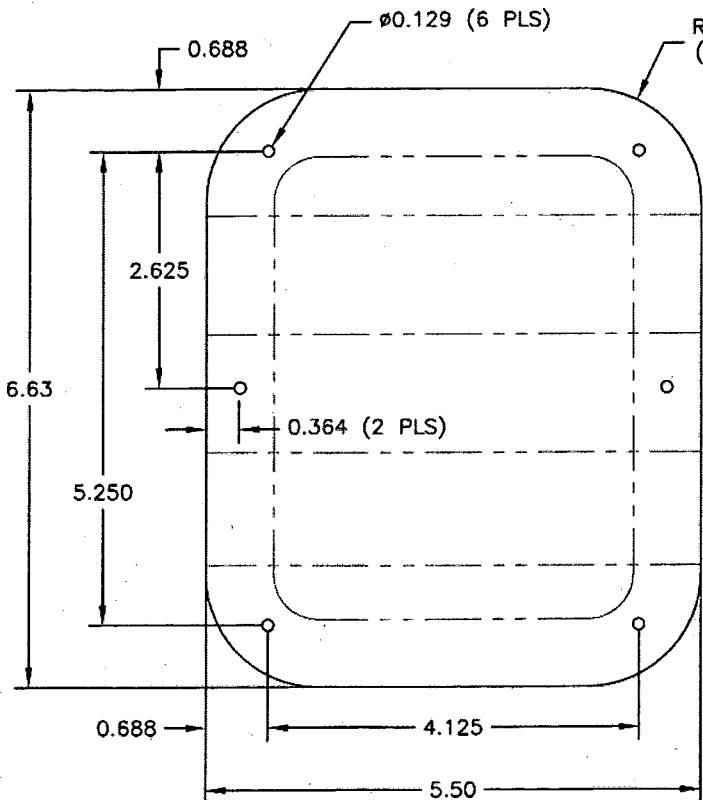
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

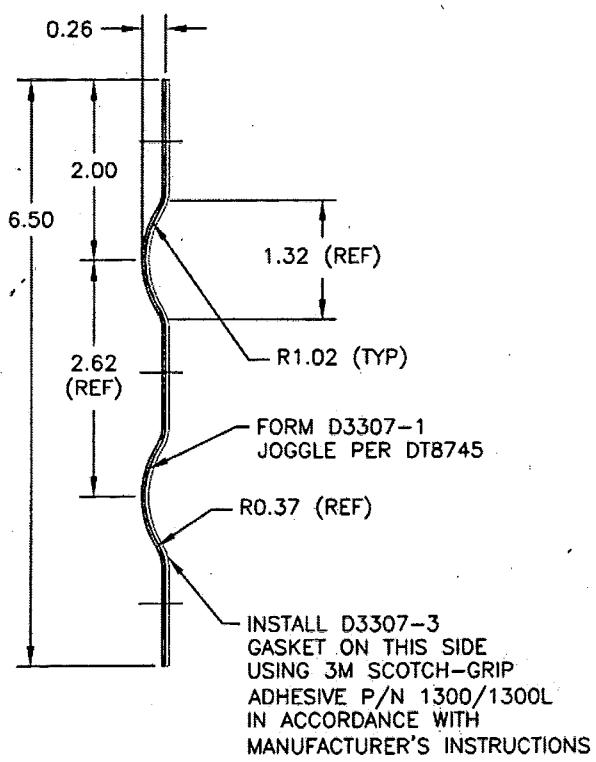


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

**RELEASED**  
05.01.18



**D3307-1 PANEL FLAT PATTERN**



**D3307-041 BEND DETAIL**

IDENTIFY WITH P/N & B/N  
USING FINE POINT  
PERMANENT MARKER

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. H2729

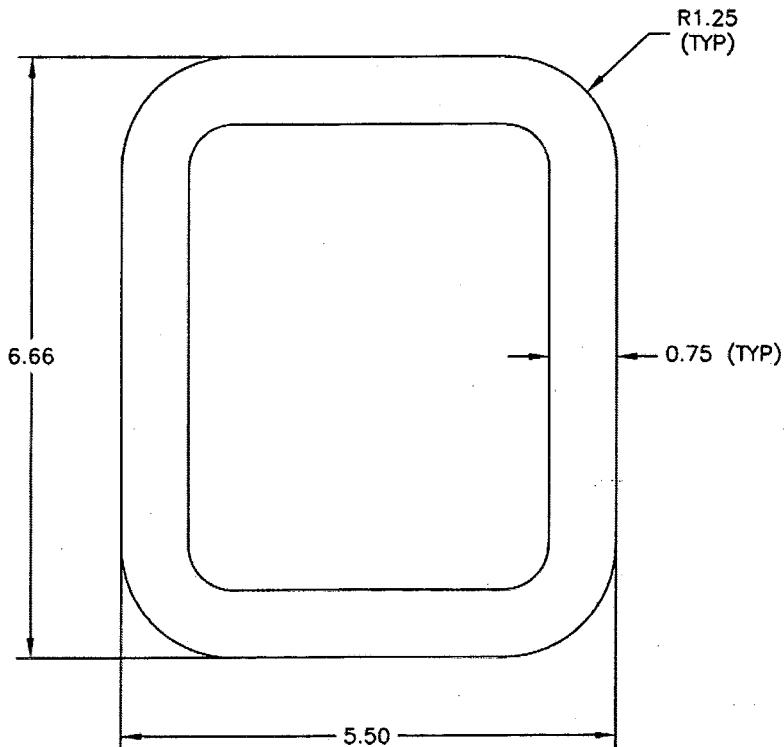
**D3307-1 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED  
05.01.18



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 42729

DART AEROSPACE LTD	Work Order:	42729
Description: ACCESS PANEL	Part Number:	D3307-1
Inspection Dwg: D3307-041, Rev: A	Page 1 of 1	

## **FIRST ARTICLE INSPECTION CHECKLIST**

## **X First Article      X Prototype**

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: <u>✓</u>
Date: <u>8-10-22</u>	Date: <u>08/10/22</u>	Date: <u>✓</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	